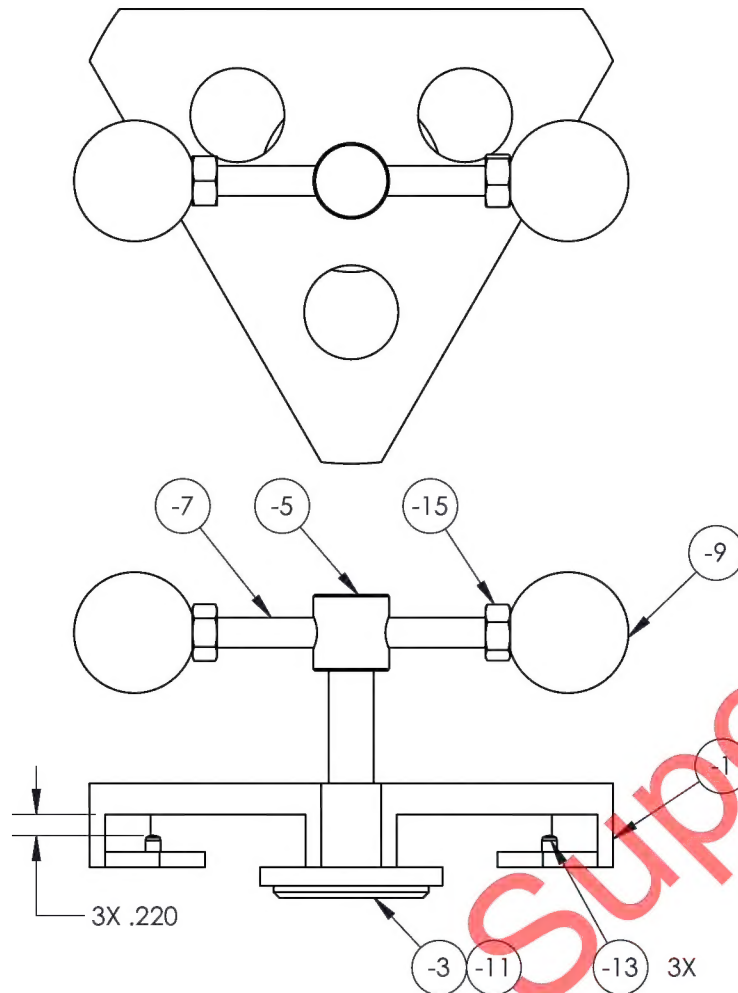


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# REVISONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
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SEE ATTACHED DEVIATION



**UNDER REVIEW**  
URF 19-722 19.06.14 (KPT)

NOTE:  
REF. EUROCOPTER T/N 117-12020W16.



RED BARN MACHINE

TITLE  
BASE EXTRACTOR FREE WHEEL

DWG NO. RBE117-12020W16 REV

MAT'L UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
DRAWN BY: CLOUGH  
APPROVED *D Weil*

.XXX ± .005 FRACTIONS ± 1/32  
.XX ± .01 ANGLES ± 5°  
.X ± .1  
HEAT TREAT  
FINISH  
SPEC

1. BREAK ALL SHARP EDGES .015 x 45°  
OR .015R

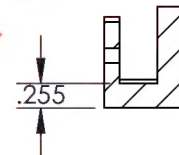
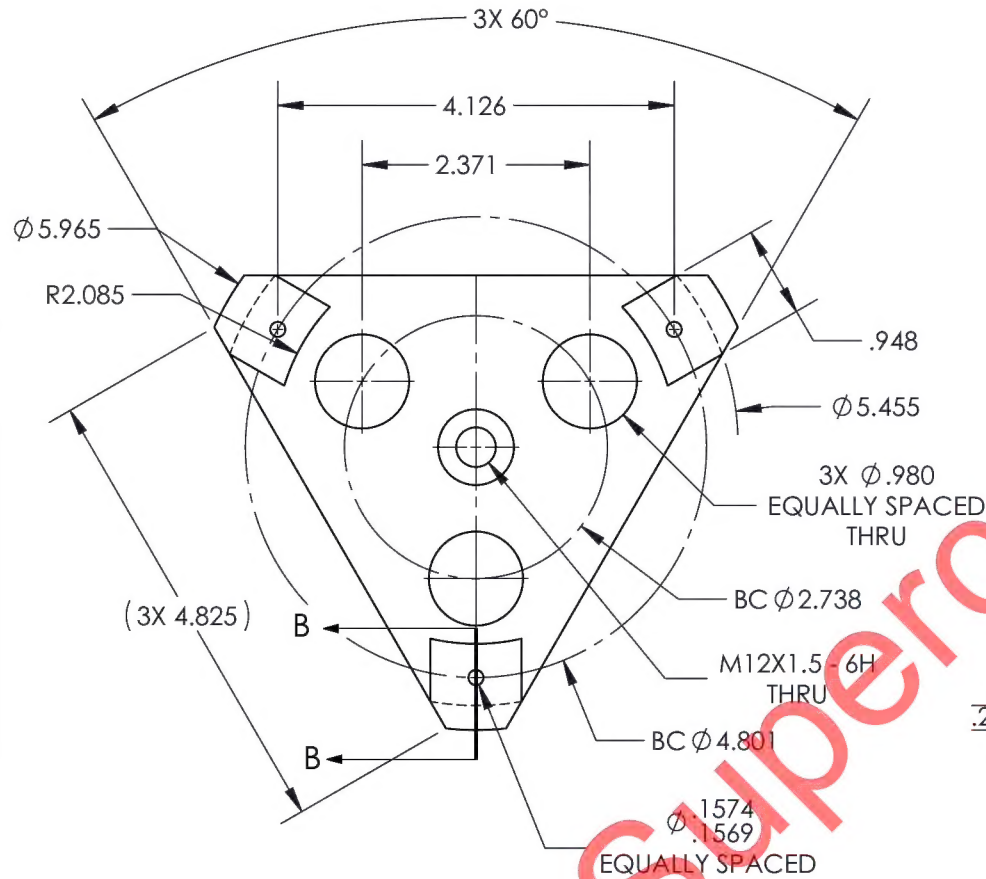
2. DIMENSIONAL LIMITS APPLY AFTER  
PLATING

SCALE 1:1 DATE 3/12/2013 SHEET 1 OF 4  
USED ON MODEL  
EUROCOPTER

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	FRAME	4140	Ø6 X 1	2
			-3	1	EXTRACTOR	1018	Ø2 X 1/2	3
			-5	1	SCREW	4140 Q&T	Ø13/16 X 3-1/4	4
		B/O	-7	1	ROD	C1541	Ø8mm X 110mm MCMaster-CARR #93275A034	1
		B/O	-9	2	HANDLE	POLYPROPYLENE	Ø32mm X M8 X1.25, BLACK MCMaster-CARR #6630T22	1
		B/O	-11	1	RETAINING RING	STEEL	Ø.165 X .02 GROOVE MCMaster-CARR #97414A620	1
		B/O	-13	3	DOWEL PIN	STEEL	Ø4mm X 8mm	1
		B/O	-15	2	HEX NUT	STEEL	M8 X 1.25 MCMaster-CARR #90685A045	1

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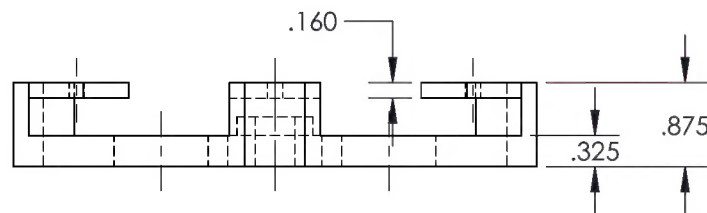
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION B-B

**SEE ATTACHED DEVIATION**

**UNDER REVIEW**  
URF 19-722 19.06.14 (KPT)



①  
FRAME

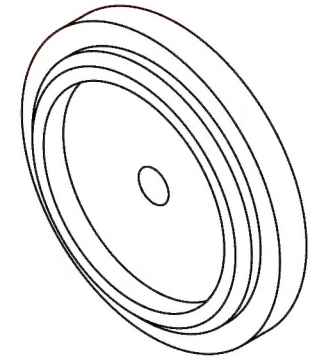
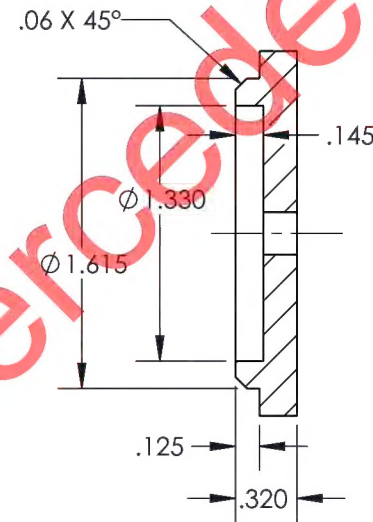
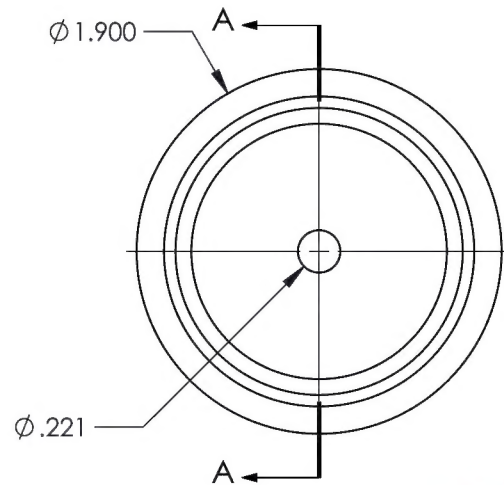
<b>RED BARN MACHINE</b>			
<b>TITLE</b> BASE EXTRACTOR FREE WHEEL			
<b>DWG NO.</b> RBE117-12020W16-1			<b>REV</b> 
<b>MAT'L</b> 4140		<b>DRAWN BY:</b> CLOUGH	
<b>UNLESS OTHERWISE SPECIFIED</b> DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		<b>APPROVED</b> 	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>HEAT TREAT</b> RC 40-44 <b>FINISH</b> BLACK OXIDE <b>SPEC</b>	
<b>SCALE</b> 1:2		<b>DATE</b> 3/12/2013	
<b>USED ON MODEL</b> EUROCOPTER		<b>SHEET 2 OF 4</b>	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

**SEE ATTACHED DEVIATION**

**UNDER REVIEW**  
URF 19-722 19.06.14 (KPT)



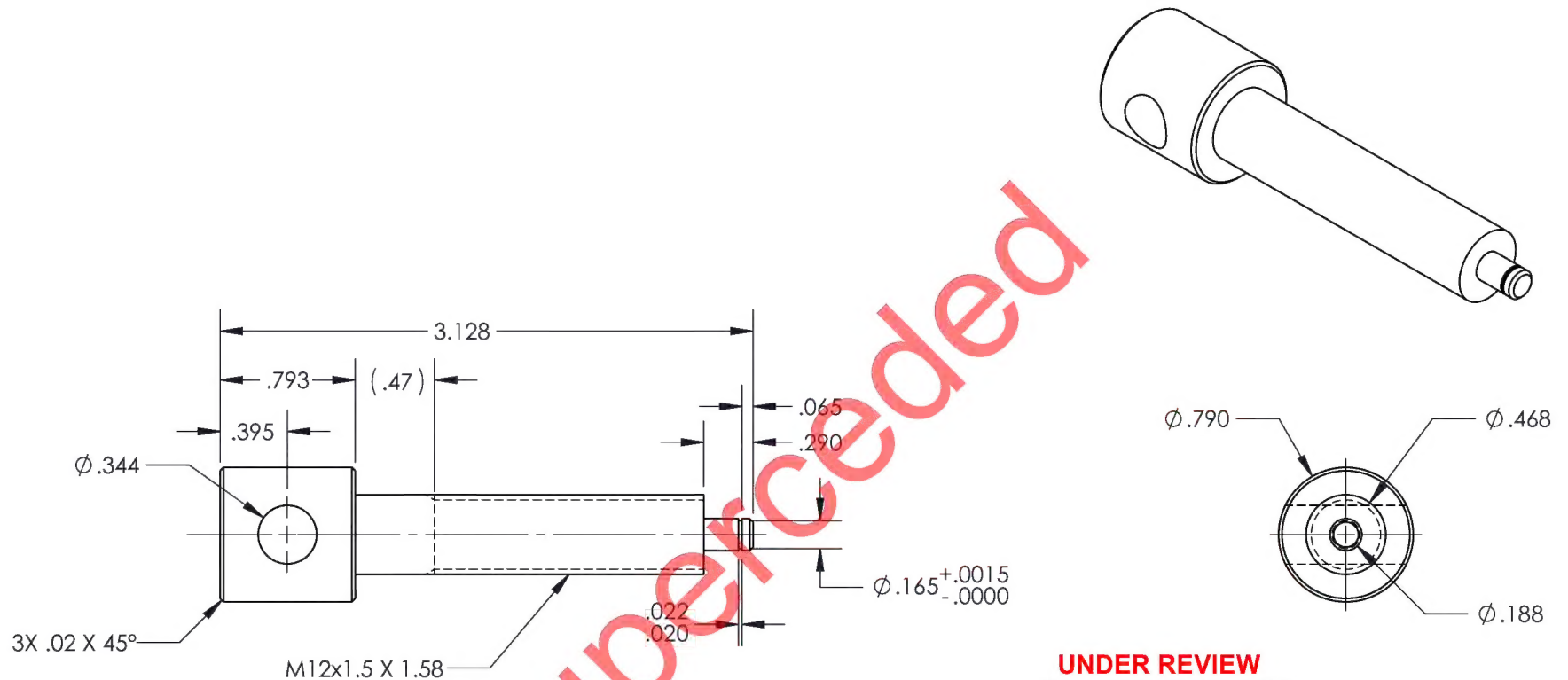
SECTION A-A  
SCALE 1 : 1

(-3)  
EXTRACTOR

<b>RED BARN MACHINE</b>	
TITLE <b>BASE EXTRACTOR FREE WHEEL</b>	
DWG NO. <b>RBE117-12020W16-3</b>	REV
MAT'L 1018	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH BLACK ANODIZE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EUROCOPTER
SCALE 1:2	DATE 3/11/2013
SHEET 3 OF 4	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



**UNDER REVIEW**  
URF 19-722 19.06.14 (KPT)

**SEE ATTACHED DEVIATION**

<b>RED BARN MACHINE</b>	
TITLE <b>BASE EXTRACTOR FREE WHEEL</b>	
DWG NO. <b>RBE117-12020W16-5</b>	REV
MAT'L 4140 Q&T	DRAWN BY: <b>CLOUGH</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EUROCOPTER
SCALE 1:2	DATE 3/11/2013
SHEET 4 OF 4	



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. <u>RBE117-12020W16-3</u> <u>REV 0</u>  NCR No. _____		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Date: <u>4/30/2019</u>		Step #:		QTY Effective :			MRB (QSI042) Approval 		
<b>Description Work Order Deviation</b>				<b>Disposition</b>				<b>Completed By</b>	
- FINISH BLACK ANODIZE IS WRONG  - SHOULD BE BLACK OXIDE				- THIS DEVIATION IS ACCEPTABLE TO USE AS IS  - FIT, FORM, AND FUNCTION WILL BE AS ORIGINALLY INTENDED					
<b>Root Cause</b>				<b>FAULT CATEGORY</b>					
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;">           Environment <input type="checkbox"/>            Design <input type="checkbox"/>            Doc/Data <input type="checkbox"/>            Equip/Tooling <input type="checkbox"/>            Handling/Pre <input type="checkbox"/>            Material <input type="checkbox"/>            Internal Transport <input type="checkbox"/>            Tribal Knowledge <input type="checkbox"/>            LOA <input type="checkbox"/>            Substation <input type="checkbox"/>            Past Expiry Date <input type="checkbox"/>            Misidentified <input type="checkbox"/> </div> <div style="width: 45%;">           No Re-verification <input type="checkbox"/>            Operator <input type="checkbox"/>            Offset/Setup <input type="checkbox"/>            Supplier <input type="checkbox"/>            Training <input type="checkbox"/>            Use for Testing <input type="checkbox"/>            Poor Information <input type="checkbox"/>            Rushing <input type="checkbox"/>            Product Improvement <input type="checkbox"/>            Process Improvement <input type="checkbox"/>            Manufacturing Process <input type="checkbox"/>            Past Due <input type="checkbox"/> </div> </div>				<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;">           Pressure/Forced <input type="checkbox"/>            Bending <input type="checkbox"/>            Centre Not Concentric <input type="checkbox"/>            Cracks <input type="checkbox"/>            Crimp/Kink/Ripple/Wave <input type="checkbox"/>            Cuffs <input type="checkbox"/>            Crushing <input type="checkbox"/>            Heat Treat <input type="checkbox"/>            Wave/Twist in Tube <input type="checkbox"/>            Marks/Chatter <input type="checkbox"/> </div> <div style="width: 45%;">           Temperature/Cure <input type="checkbox"/>            Set-up <input type="checkbox"/>            BOM/Route <input type="checkbox"/>            Broken/Damage/Defect <input type="checkbox"/>            Inspection Incomplete/Unqualified <input type="checkbox"/>            Contamination <input type="checkbox"/>            Countersink <input type="checkbox"/>            Cut Too Short <input type="checkbox"/>            Instructions Incomplete/Unclear <input type="checkbox"/>            Drill Holes <input type="checkbox"/> </div> </div>					
				<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;">           Power Loss/Surge <input type="checkbox"/>            Folio/Program <input type="checkbox"/>            Grain <input type="checkbox"/>            Weld <input type="checkbox"/>            Wrong Stock Pulled <input type="checkbox"/>            Out of Sequence <input type="checkbox"/>            Off-set <input type="checkbox"/>            Misabeled <input type="checkbox"/>            Fit/Function <input type="checkbox"/>            Misaligned/off center <input type="checkbox"/> </div> <div style="width: 45%;">           Positioned Wrong <input type="checkbox"/>            Outside Dimensions <input type="checkbox"/>            Over/Under tolerance <input type="checkbox"/>            Part Incorrect <input type="checkbox"/>            Part Lost/Missing <input type="checkbox"/>            Part Moved <input type="checkbox"/>  <input checked="" type="checkbox"/> Drawing <input type="checkbox"/>            Finish <input type="checkbox"/>            Misread <input type="checkbox"/>            Turning Sequence <input type="checkbox"/> </div> </div>					
OTHER : <input type="checkbox"/>									